

**WHAT IS CLAIMED IS:**

1. A coated article comprising:

a layer system supported by a glass substrate, said layer system comprising an infrared (IR) reflecting silver layer located between first and second dielectric layers; and

5 wherein said coated article has a  $\Delta E^*$  value (glass side) no greater than 3.0 after or due to heat treatment.

2. The coated article of claim 1, wherein said coated article has a  $\Delta E^*$  value (glass side) no greater than 2.5 following or due to heat treatment.

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3. The coated article of claim 1, wherein said coated article has a  $\Delta E^*$  value (glass side) no greater than 2.0 following or due to thermal tempering of the coated article, and

wherein said coated article has a color characterized by  $a^*_G$  and  $b^*_G$  color coordinate values of the coated article both being negative both before and after heat

15 treatment of the coated article.

4. The coated article of claim 1, wherein said layer system further includes a first layer including Ni or NiCr located between said silver layer and said first dielectric layer, and a second layer including Ni or NiCr located between said silver layer and said second

20 dielectric layer.

5. The coated article of claim 4, wherein said coated article has a  $\Delta a^*_G$  value (glass side, absolute value) no greater than 1.0 after or due to heat treatment.

6. The coated article of claim 5, wherein said coated article has a  $\Delta a^*_G$  value (glass side, absolute value) no greater than 0.8 after or due to heat treatment.

7. The coated article of claim 1, wherein said coated article has a hemispherical emissivity ( $E_h$ ) of no greater than 0.25, both before and after heat treatment.

8. The coated article of claim 4, wherein said coated article has a hemispherical emissivity ( $E_h$ ) of no greater than 0.20, both before and after heat treatment.

9. The coated article of claim 4, wherein said coated article has a sheet resistance value  $R_s$  no greater than 20 ohms/square before heat treatment.

10. The coated article of claim 9, wherein said coated article has a sheet resistance value  $R_s$  no greater than 15 ohms/square, both before and after heat treatment.

11. The coated article of claim 10, wherein said coated article has a sheet resistance value  $R_s$  no greater than 12 ohms/square, both before and after heat treatment.

12. The coated article of claim 4, wherein said first and second dielectric layers comprise silicon nitride.

13. The coated article of claim 12, wherein each of said first and second Ni or NiCr  
5' inclusive layers is at least 20 angstroms (Å) thick.

14. The coated article of claim 13, wherein said layer system comprises the recited layers at the following thicknesses, where the first silicon nitride inclusive layer is located between the glass substrate and the first Ni or NiCr inclusive layer:

10 first silicon nitride inclusive layer: 300-380 Å thick

first Ni or NiCr inclusive layer: 20-150 Å thick

silver layer: 40-120 Å thick

second Ni or NiCr inclusive layer: 20-150 Å thick

second silicon nitride inclusive layer: 400-500 Å thick.

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15. The coated article of claim 14, wherein said layer system comprises the recited layers at the following thicknesses:

first silicon nitride inclusive layer: 320-360 Å thick

first Ni or NiCr inclusive layer: 20-90 Å thick

20 silver layer: 60-80 Å thick

second Ni or NiCr inclusive layer: 20-90 Å thick

second silicon nitride inclusive layer: 420-480 Å thick.

16. The coated article of claim 1, wherein the coated article makes up a portion of  
5 an insulating glass (IG) window unit.

17. A coated article comprising:

a substrate;

a layer system provided on the substrate, said layer system comprising from the  
10 glass outwardly, a first silicon nitride inclusive layer, a first Ni or NiCr inclusive layer, an  
IR reflecting metal layer, a second Ni or NiCr inclusive layer, and a second silicon nitride  
inclusive layer;

wherein each of said first and second Ni or NiCr inclusive layers is at least about 20  
Å thick; and

15 wherein said coated article has a hemispherical emissivity ( $E_h$ ) of no greater than  
0.25 before heat treatment, a sheet resistance  $R_s$  no greater than 20 ohms/square before  
heat treatment, and a  $\Delta E^*$  value (glass side) no greater than 2.5 after or due to heat  
treatment.

18. The coated article of claim 17, wherein said coated article has a  $\Delta E^*$  value (glass side) no greater than 2.0 following thermal tempering of the coated article.

19. The coated article of claim 17, wherein said coated article has a color characterized by  $a^*_G$  and  $b^*_G$  color coordinate values of the coated article both being negative both before and after heat treatment of the coated article.

20. The coated article of claim 17, wherein said coated article has a  $\Delta a^*_G$  value (glass side, absolute value) no greater than 1.0 after or due to heat treatment.

21. The coated article of claim 20, wherein said coated article has a  $\Delta a^*_G$  value (glass side, absolute value) no greater than 0.8 after or due to heat treatment.

22. The coated article of claim 17, wherein said IR reflecting metal layer comprises silver.

23. A method of making a coated article, the method comprising:  
depositing a layer system on a glass substrate, the layer system including an infrared (IR) reflecting metal layer located between first and second dielectric layers, wherein prior to heat treatment the glass substrate with the layer system thereon has a sheet resistance  $R_s$  no greater than 20 ohms/square; and

heat treating the substrate with the layer system thereon so that due to said heat treating the resulting substrate with the layer system thereon has a  $\Delta E^*$  value (glass side) no greater than 2.5.

5' 24. The method of claim 23, wherein said heat treating comprises thermally tempering the substrate with the layer system thereon.

25. The method of claim 23, wherein said depositing comprises sputtering.

10 26. The method of claim 23, wherein the layer system comprises, from the substrate outwardly at the following thicknesses:

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|--|------------------|
| a) first silicon nitride inclusive layer:  | 300-380 Å thick  |
| b) first Ni or NiCr inclusive layer:       | 20-150 Å thick   |
| c) silver layer:                           | 40-120 Å thick   |
| 15 d) second Ni or NiCr inclusive layer:   | 20-150 Å thick   |
| e) second silicon nitride inclusive layer: | 400-500 Å thick. |

27. A method of making a coated article, the method comprising:

sputtering a layer system onto a glass substrate to form a coated substrate, the layer  
 20 system comprising a metal infrared (IR) reflecting layer located between first and second

dielectric layers; and

thermally tempering the coated substrate including the glass substrate with the layer system thereon, so that the coated substrate has a  $\Delta E^*$  value (glass side) no greater than 2.5 and a hemispherical emissivity ( $E_h$ ) no greater than 0.25.

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28. The coated article of claim 1, wherein the coated article has an  $a^*_G$  value of from about 0.0 to  $-4.0$  before and after heat treatment, and a  $b^*_G$  value that is negative both before and after heat treatment.

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29. The coated article of claim 28, wherein the coated article has an  $a^*_G$  value of from about 0.0 to  $-2.5$  before and after heat treatment.

30. A coated article comprising:

a glass substrate;

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a layer system provided on the substrate, said layer system comprising from the glass outwardly, a first silicon nitride inclusive layer 300 to 380 Å thick, a first Ni or NiCr inclusive layer from 25 to 45 Å thick, a silver layer from 60-100 Å thick, a second Ni or NiCr inclusive layer from 25 to 45 Å thick, and a second silicon nitride inclusive layer; and

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wherein said coated article has a hemispherical emissivity ( $E_h$ ) of no greater than 0.25 and a sheet resistance  $R_s$  no greater than 20 ohms/square.

31. The coated article of claim 30, wherein the coated article is heat treated and has a  $\Delta E^*$  value (glass side) no greater than 2.5.

5 32. An insulating glass (IG) window unit comprising:  
first and second glass substrates sealed together proximate their respective  
peripheral edges so as to form an insulating space therebetween;  
a layer system supported by one of said glass substrates proximate said insulating  
space, said layer system comprising an infrared (IR) reflecting silver layer located between  
10 first and second dielectric layers; and  
wherein said IG unit has a  $\Delta E^*$  value (exterior or outside) no greater than 3.0 after  
or due to heat treatment.

33. The IG unit of claim 32, wherein said IG unit has a  $\Delta E^*$  value (exterior or  
15 outside) no greater than 2.5 following or due to heat treatment.

34. The IG unit of claim 33, wherein said IG unit has a  $\Delta E^*$  value (exterior or  
outside) no greater than 2.0 following or due to thermal tempering, and wherein said IG  
unit has a color characterized by  $a^*_G$  and  $b^*_G$  color coordinate values both being negative.



35. The IG unit of claim 33, wherein said IG unit has a  $\Delta E^*$  value (exterior or outside) no greater than 1.5 following or due to thermal tempering.

36. The IG unit of claim 32, wherein said layer system further includes a first layer including Ni or NiCr located between said silver layer and said first dielectric layer, and a second layer including Ni or NiCr located between said silver layer and said second dielectric layer.

37. The IG unit of claim 36, wherein said IG unit has a  $\Delta a^*$  value (exterior or outside) no greater than 1.0.

38. The IG unit of claim 37, wherein said IG unit has a  $\Delta a^*$  value (exterior or outside) no greater than 0.8 after or due to heat treatment.

39. The IG unit of claim 32, wherein said one substrate with said layer system thereon has a hemispherical emissivity ( $E_b$ ) of no greater than 0.25.

40. The IG unit of claim 39, wherein said one substrate with said layer system thereon has a hemispherical emissivity ( $E_b$ ) of no greater than 0.20.

41. The IG unit of claim 32, wherein said one substrate with said layer system thereon has a sheet resistance value  $R_s$  no greater than 20 ohms/square.

42. The IG unit of claim 41, wherein said one substrate with said layer system thereon has a sheet resistance value  $R_s$  no greater than 15 ohms/square.

43. The IG unit of claim 42, wherein said one substrate with said layer system thereon has a sheet resistance value  $R_s$  no greater than 12 ohms/square.

44. The IG unit of claim 36, wherein said first and second dielectric layers comprise silicon nitride.

45. The IG unit of claim 44, wherein each of said first and second Ni or NiCr inclusive layers is at least 20 angstroms ( $\text{\AA}$ ) thick.

46. The IG unit of claim 45, wherein said layer system comprises the recited layers at the following thicknesses, where the first silicon nitride inclusive layer is located between said one glass substrate and the first Ni or NiCr inclusive layer:

first silicon nitride inclusive layer: 300-380  $\text{\AA}$  thick

first Ni or NiCr inclusive layer: 20-150  $\text{\AA}$  thick

silver layer: 40-120  $\text{\AA}$  thick

second Ni or NiCr inclusive layer: 20-150 Å thick

second silicon nitride inclusive layer: 400-500 Å thick.

47. The coated article of claim 46, wherein said layer system comprises the recited  
5 layers at the following thicknesses:

first silicon nitride inclusive layer: 320-360 Å thick

first Ni or NiCr inclusive layer: 20-90 Å thick

silver layer: 60-80 Å thick

second Ni or NiCr inclusive layer: 20-90 Å thick

10 second silicon nitride inclusive layer: 420-480 Å thick.

48. An insulating glass (IG) unit comprising:

first and second substrates sealed together;

15 a layer system provided on said first substrate, said layer system comprising from  
the first substrate outwardly, a first silicon nitride inclusive layer, a first Ni or NiCr  
inclusive layer, an IR reflecting metal layer, a second Ni or NiCr inclusive layer, and a  
second silicon nitride inclusive layer, wherein each of said first and second Ni or NiCr  
inclusive layers is at least about 20 Å thick; and

20 wherein said first substrate with said layer system thereon has a hemispherical  
emissivity ( $E_h$ ) of no greater than 0.25 before heat treatment, a sheet resistance  $R_s$ , no

greater than 20 ohms/square before heat treatment, and a  $\Delta E^*$  value (glass side or outside) no greater than 2.5 after or due to heat treatment.

49. The IG unit of claim 48, wherein said first substrate with said layer system thereon has a  $\Delta E^*$  value no greater than 2.0.

50. A thermally insulating panel assembly comprising:

first and second substrates seal together proximate their respective peripheries to form an insulating space therebetween;

10 a layer system provided on said first substrate, said layer system comprising from the first substrate outwardly, a first silicon nitride inclusive layer 300 to 380 Å thick, a first Ni or NiCr inclusive layer from 20 to 90 Å thick, a silver layer from 40-120 Å thick, a second Ni or NiCr inclusive layer from 20 to 90 Å thick, and a second silicon nitride inclusive layer; and

15 wherein said first substrate with said layer system thereon has a hemispherical emissivity ( $E_h$ ) of no greater than 0.25 and a sheet resistance  $R_s$  no greater than 20 ohms/square.

51. The panel assembly of claim 50, wherein the first substrate with said layer system thereon is heat treated and has a  $\Delta E^*$  value (outside or substrate side) no greater than 2.5.

52. A coated article comprising:

a layer system supported by a glass substrate, said layer system comprising an infrared (IR) reflecting silver layer located between first and second dielectric layers; and

5' wherein said coated article is characterized by a glass side or outside  $R_{\text{solar}}$  which is greater than a glass side or outside visible reflectance  $R_{(\text{G or out})}$ ; and a visible transmittance ( $T_Y$  or  $T_{\text{vis}}$ ) of from about 10-65%.

53. The coated article of claim 52, wherein said coated article has a  $\Delta E^*$  value  
10 (glass side) no greater than 2.5 after or due to heat treatment.

54. The coated article of claim 52, wherein said layer system further includes a first layer including Ni or NiCr located between said silver layer and said first dielectric layer, and a second layer including Ni or NiCr located between said silver layer and said second  
15 dielectric layer.

55. The coated article of claim 54, wherein said coated article has a hemispherical emissivity ( $E_h$ ) of no greater than 0.20, both before and after heat treatment.

20 56. The coated article of claim 55, wherein said coated article has a sheet resistance value  $R_s$  no greater than 20 ohms/square before heat treatment.

57. The coated article of claim 55, wherein said first and second dielectric layers comprise silicon nitride.

58. The coated article of claim 52, wherein the coated article makes up a portion of an insulating glass (IG) window unit.